

Ship 07-24

Work Order ID 164040

164040

Page 1

Tuesday, July 11, 2017 2:41:35 PM

Item ID: D412-760-111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Cabin Wall & Pylon Protector

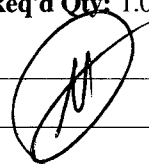
Start Date: 7/19/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:  Date: JUL 11 2017

Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-760	G

100 Document Control

DAS
6
JUL 17 2017

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-760-111 CHG002

DAS
28
JUL 18 2017

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
JUL 18 2017

DAS
27
JUL 18 2017

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

DAS
28
JUL 18 2017

JUL 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																						OTHER : _____																																									

Work Order ID 164040

Tuesday, July 11, 2017 2:41:35 PM

164040

Page 2

Item ID: D412-760-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Cabin Wall & Pylon Protector

Stop ***NS2***

Start Date: 7/19/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-760-011

Location: FG040

DAS
27
9-89

JUL 18 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-89

JUL 19 2017

DAS
21
9-89

JUL 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Tuesday, July 11, 2017 2:41:35 PM

164040

D412-760-111

Required Date: 7/24/2017

Required Qty: 1.00

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3933-1 *D3933-1* Aft Wall Protector		Manufactured	No			110	Each	0.0000	1	1	1	DAS 6 JUL 13 2017 9-89	DAS 27 9-89
D3933-2 *D3933-2* Aft Wall Protector, RH		Manufactured	No			110	Each	0.0000	1	1	1	DAS 6 JUL 13 2017 9-89	DAS 27 9-89
D3935-1 *D3935-1* Pylon Wall Protector, LH		Manufactured	No			110	Each	0.0000	1	1	1	DAS 6 JUL 18 2017 9-89	DAS 27 9-89
D3935-2 *D3935-2* Pylon Wall		Manufactured	No			110	Each	0.0000	1	1	1	DAS 6 JUL 18 2017 9-89	DAS 27 9-89
D3942-1 *D3942-1* Angle		Manufactured	No			110	Each	32.0000	14	14	14	DAS 6 JUL 18 2017 9-89	DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST058		32							
				154542		2							
				155296		2							
				158851		28							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective: _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER: ☐					

Picklist Print

Tuesday, July 11, 2017 2:41:35 PM

Page 2

Work Order ID: 164040

164040

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 7/19/2017

Required Date: 7/24/2017

Start Qty: 1.00

Required Qty: 1.00

D3942-3

Manufactured No

110

Each

45.0000

10 10

D3942-3

Clip

**

DAS 27
JUL 18 2017 9-89

Location

Loc Qty

Loc Code

ST058

45

154513

3

155246

2

160095

40

MS27039-4-10

Purchased

No

110

Each

88.0000

4 4

MS27039-4-10

Screw

**

DAS 27
JUL 18 2017 9-89

Location

Loc Qty

Loc Code

ST279

88

m135603

88

MS27039-4-14

Purchased

No

110

Each

8.0000

6 6

MS27039-4-14

SCREW

**

DAS 27
JUL 18 2017 9-89

Location

Loc Qty

Loc Code

ST279

8

m135058

8

MS27039-5-08

Purchased

No

110

Each

19.0000

6 6

MS27039-5-08

Screw

**

DAS 27
JUL 18 2017 9-89

Location

Loc Qty

Loc Code

ST279

19

m135359

19

DAS 28
9-89

Tuesday, July 11, 2017 2:41:35 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

Tuesday, July 11, 2017 2:41:35 PM

Page 3

Work Order ID: 164040

164040

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 7/19/2017

Required Date: 7/24/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-5-12

Purchased

No

110

Each

22.0000

8

8

MS27039-5-12

Screw

**

DAS

6

9-89

JUL 18 2017

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST278

22

m136182

6

m136648

16

6
2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																						OTHER : ☐																																									

164040

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: (7/19/2017) **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/24/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals:

Process Plan:

Date: JUL 11 2017

Tooling:

Date:

Run Start *NR1*

OC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Draw Nbr	Revision Nbr	
IIN D412-760	G	117 7888

JUL 17 1968

0.00

100

0.00

DC

Memo

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-760-111 CHG002

110

Pick Kit

0.00

110

0.00

Packaging

Memo

Packaging

~120

QC4- 100% Inspect kits for completeness

0.00

120

0.03

QC

Memo

Quality Control



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH07-37

Issue No.: 3

Approval Date: June 29, 2007

Issue Date: July 28, 2010

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

BELL 205A, 205A-1, 205B, 212, 214B, 214B-1, 412, 412 CF, 412 EP

Canadian Type Certificate or Equivalent:

BELL 205B H-104
BELL 214B, 214B-1 H-80
BELL 212, 412, 412 CF, 412 EP H-86
BELL 205A, 205A-1 H1SW

Description of Type Design Change:

Interior Protector Kits

Installation/Operating Data,
Required Equipment and Limitations:

Manufacture of the Interior Protector Kits must be in accordance with Dart Aerospace Ltd. MDL-D412-760, Revision G, dated December 2, 2009, or later approved revision.

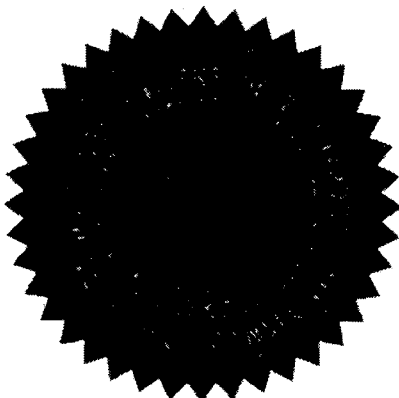
Installation of the Interior Protector Kits must be in accordance with Dart Aerospace Ltd. IIN-D412-760, Revision E, dated December 2, 2009, or later approved revision.

Maintenance of the Interior Protector Kits must be in accordance with the Transport Canada accepted Dart Aerospace Ltd. ICA-D412-760, Revision 4, dated December 2, 2009, or later Transport Canada accepted revisions.

Basis of Certification:

The basis of certification for affected areas is CFR 14, Part 29, up to and including Amendment 29-47.

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.

Greg Oucharek
For Minister of Transport

Canada

Qty -111	Qty -113	Part Number	Description
X		D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
	X	D412-760-113	AFT CABIN WALL AND PYLON PROTECTOR KIT
1	1	D3933-1	LH AFT CABIN WALL PROTECTOR
1	1	D3933-2	RH AFT CABIN WALL PROTECTOR
1		D3935-1	LH PYLON PROTECTOR
1		D3935-2	RH PYLON PROTECTOR
	1	D3935-3	LH PYLON PROTECTOR
	1	D3935-4	RH PYLON PROTECTOR
14	14	D3942-1	ANGLE
10	10	D3942-3	CLIP
4	4	MS27039-4-10	SCREW
6	6	MS27039-4-14	SCREW
6	6	MS27039-5-08	SCREW
8	8	MS27039-5-12	SCREW

Qty -211	Qty -213	Qty -215	Qty -217	Part Number	Description
X				D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
	X			D412-760-213	BAGGAGE COMPARTMENT CEILING PROTECTOR KIT
		X		D412-760-215	CARGO FLOOR PROTECTOR KIT
			X	D412-760-217	LIGHTWEIGHT BAGGAGE COMPARTMENT PROTECTOR KIT
36	7	8		D3628-1	CUPPED WASHER
			43	D3628-5	CUPPED WASHER
1				D3876-1	RH FORWARD WALL PROTECTOR
1				D3876-3	FORWARD WALL PROTECTOR
1				D3876-5	LH WALL PROTECTOR
1				D3876-7	AFT WALL PROTECTOR
1				D3876-9	RH AFT WALL PROTECTOR
1		1		D3876-11	FLOOR PROTECTOR
1				D3876-13	DOOR PROTECTOR
1		1		D3952-1	PLACARD
			1	D3952-3	PLACARD
	1			D4438-1	CEILING PROTECTOR
			1	D4640-1	RH FWD WALL PROTECTOR
			1	D4640-3	FORWARD WALL PROTECTOR
			1	D4640-5	LH WALL PROTECTOR
			1	D4640-7	AFT WALL PROTECTOR
			1	D4640-9	RH AFT WALL PROTECTOR
			1	D4640-11	FLOOR PROTECTOR
			1	D4640-13	DOOR PROTECTOR
			1	D4640-15	CEILING PROTECTOR
36		8	36	80-004-2-6	INSERT
	7		7	80-004-2-8	INSERT
36		8	36	MS27039-1-04	SCREW
	7		7	MS27039-1-05	SCREW
	3		3	MS27039-1-10	SCREW
	6		6	NAS1149F0363P	WASHER (AN960-10)

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Revision: G

Date: 13.01.03